

Date: Wednesday, 12/11/2008 1:40:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT FRAME ASSEMBLY
Job Number	: 43379		
Estimate Number	: 11122		
P.O. Number	:	Part Number	: D3016041
This Issue	: 12/11/2008 S.O. No. :	Drawing Number	: D3016 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 42441	Material	:
Written By	:	Due Date	: 05/12/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 08.11.12</u>		
Comment	: Est. A 01.09.19 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

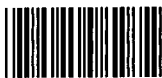
1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
-----	-----------------	--------------------------



Comment: Qty.: 4.5150 f(s)/Unit Total: 4.5150 f(s)
 4130 Tube .750 OD x.049W
 Cut- AISI 4130N tube, Ø3/4" x 0.049" wall
 Batch: M103012

08/11/21

2.0	M4130NT1000W120	4130 RD Tube 1.00 x .120wall
-----	-----------------	------------------------------



Comment: Qty.: 1.5750 f(s)/Unit Total: 1.5750 f(s)
 4130 Tube 1.0"D X 0.120"W
 batch M108538

08/11/21

3.0	M4130NT0500W049	4130 RD Tube .500 x.049W
-----	-----------------	--------------------------



Comment: Qty.: 4.5150 f(s)/Unit Total: 4.5150 f(s)
 4130 Tube .500 OD x.049W
 Cut- AISI 4130N tube, Ø1/2" x 0.049" wall
 Batch: M106651

08/11/21

4.0	D301617	Gusset
-----	---------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Gusset
 Pick:

Qty	Part Number	Description	Batch
2	D3016-17	Gusset	<u>B39641</u>

08/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:40:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 43379

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D301613

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
2	D3016-13	Bracket	B34208

08/11/21

6.0

D301615

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
2	D3016-15	Gusset	B43413

08/11/21

7.0

D30201

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
4	D3020-1	Fitting	B36713

08/11/21

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M19317

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

08/11/21

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 08/11/24 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:40:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 43379

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

800124 (H)

11.0

POWDER COATING

POWDER COATING



M 109648



(IX)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20
320 OF
10:30

M-L 08/11/24

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

43345

JS 08/11/24 (X)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 (H)

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

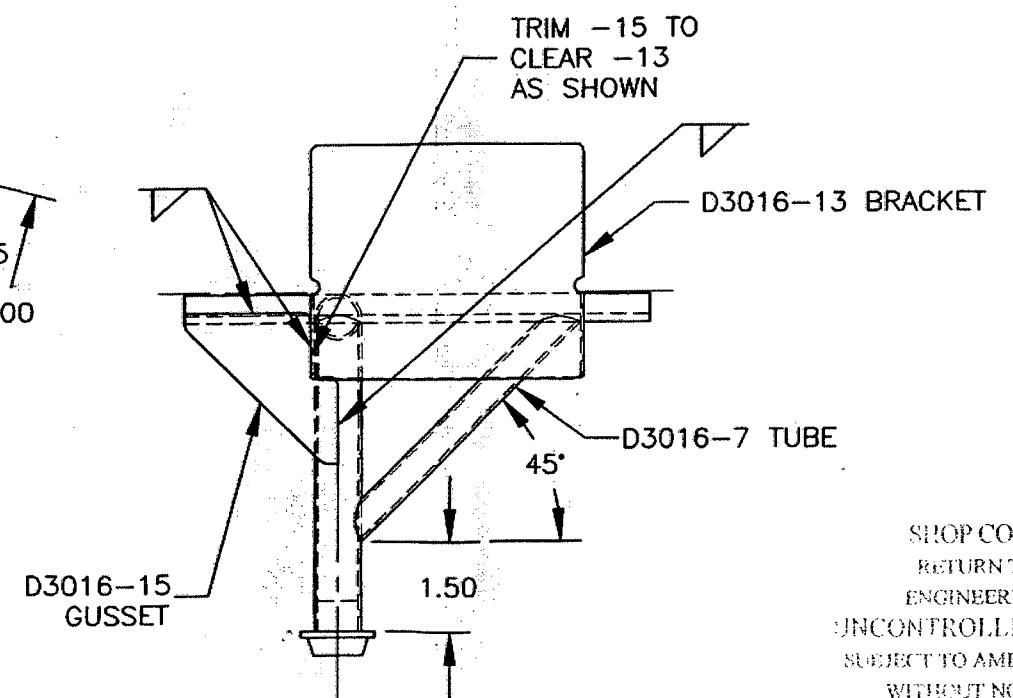
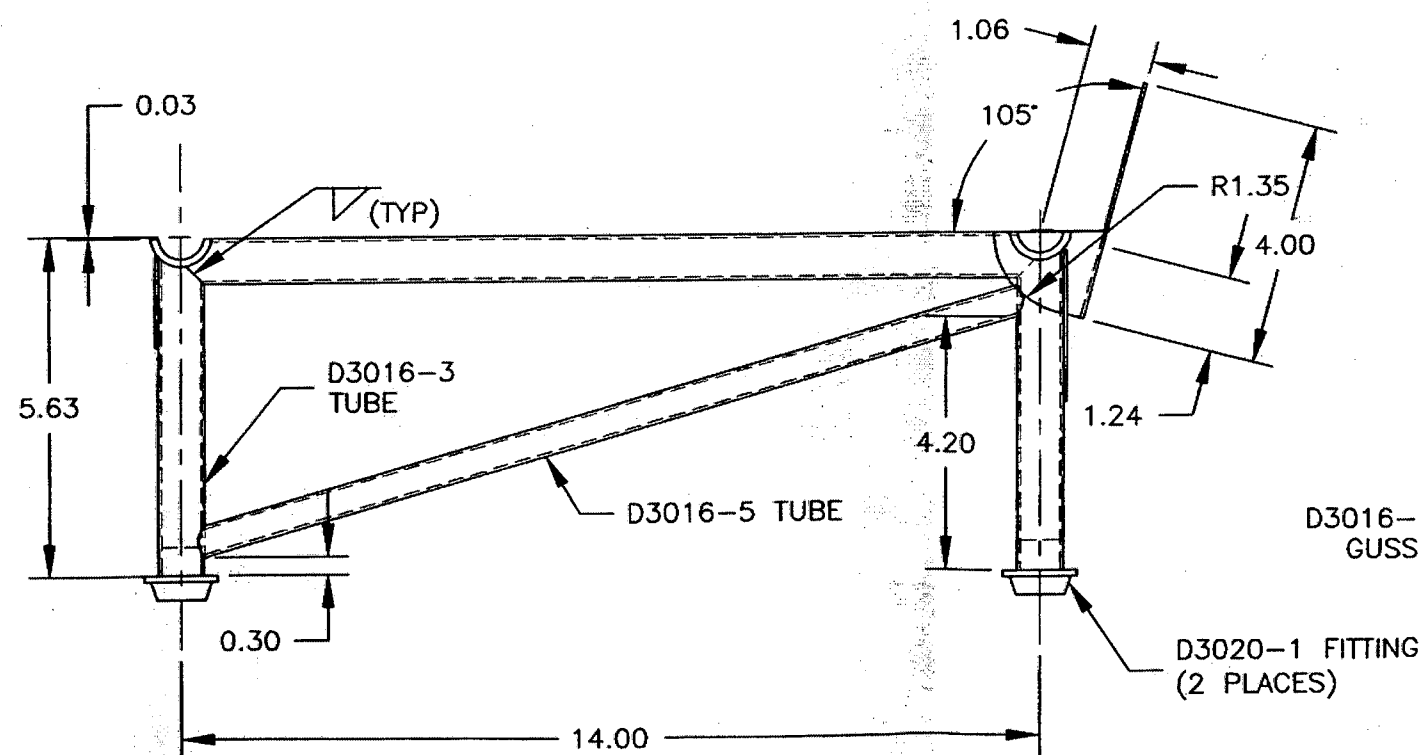
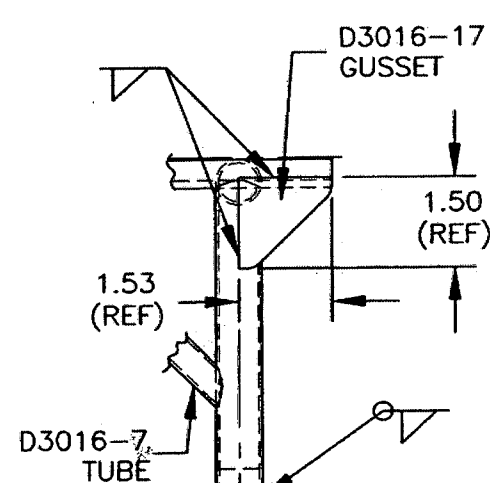
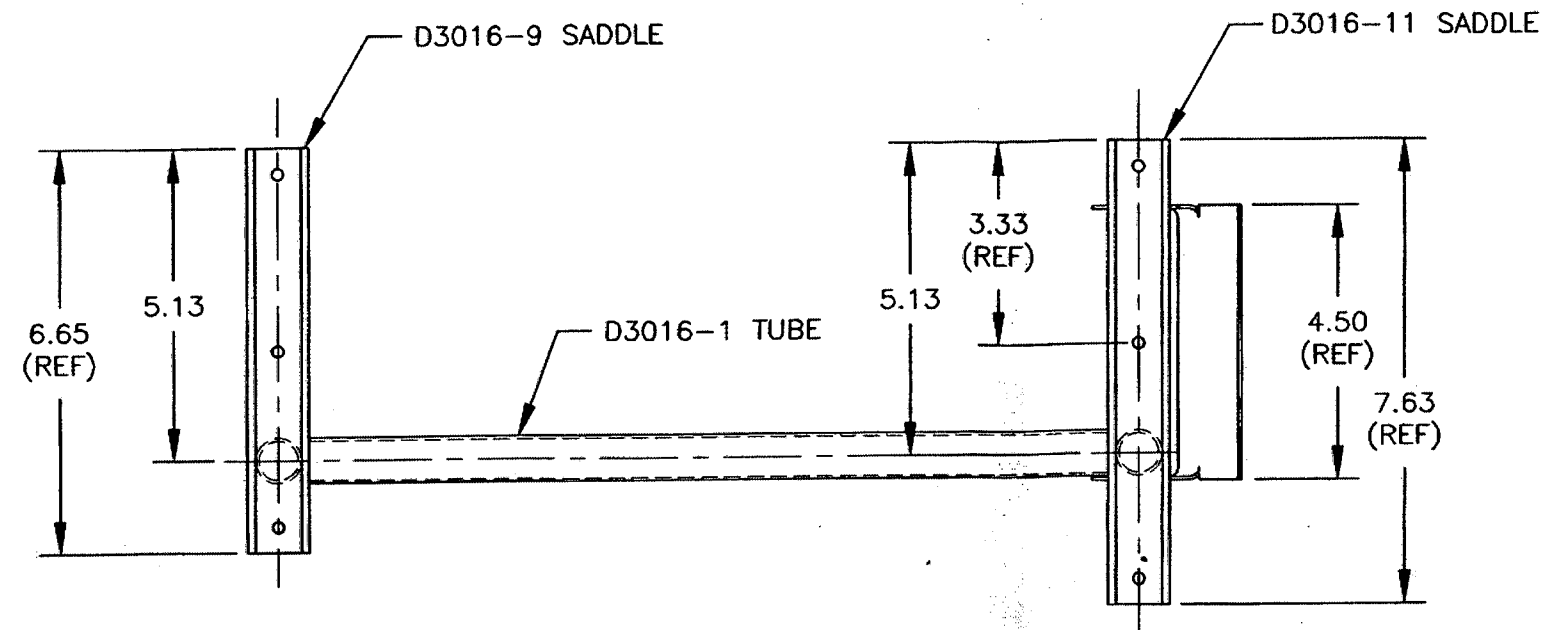
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43379

RELEASED
01.05.30 *#*

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

D3016-041 SEAT FRAME ASSEMBLY



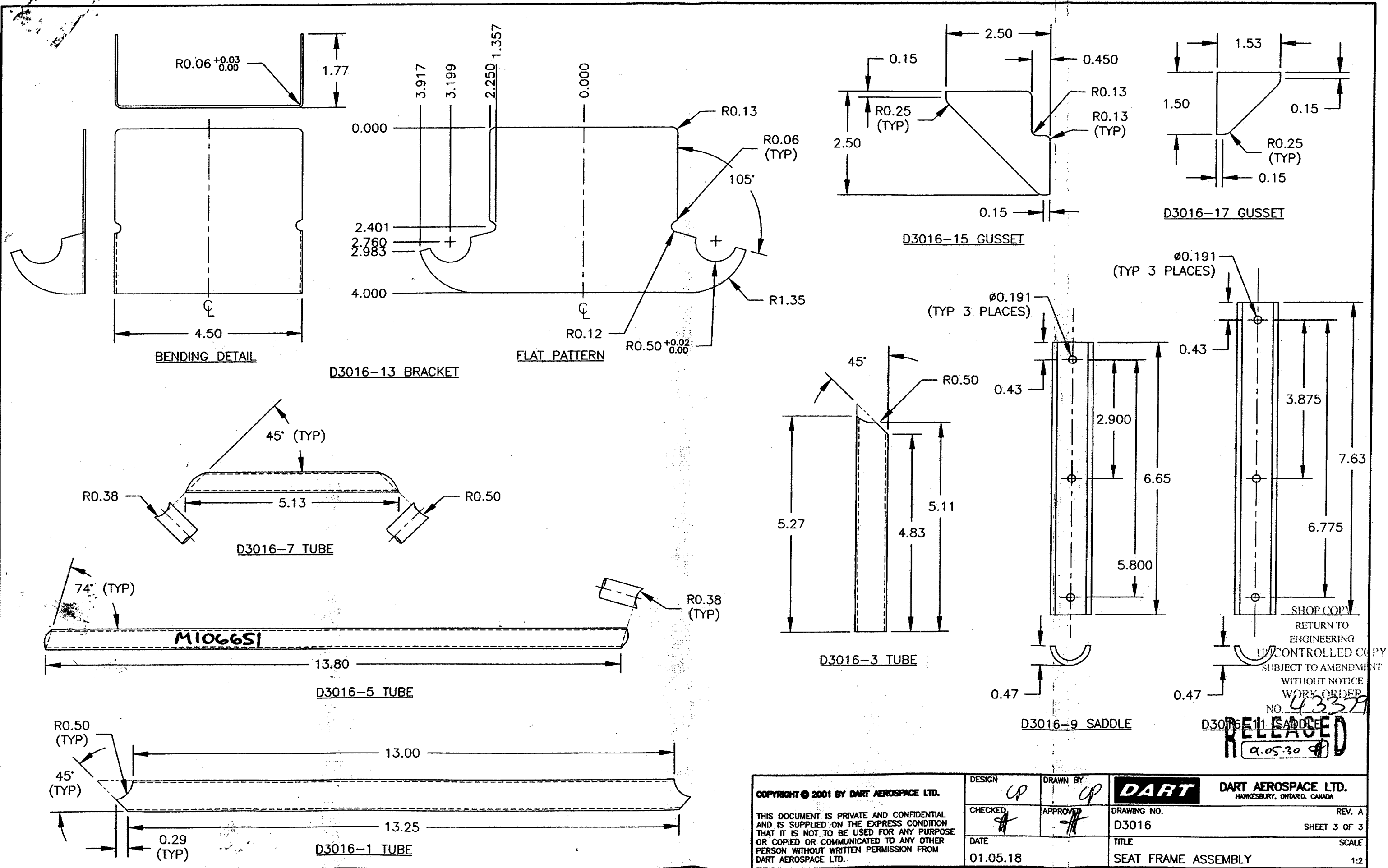
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43379

RELEASED
01.05.30

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SHEET 2 OF 3 SCALE 1:3



COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
	CHECKED	APPROVED	
	DATE	TITLE	
	01.05.18	SEAT FRAME ASSEMBLY	
DRAWING NO. D3016			REV. A
			SHEET 3 OF 3
			SCALE 1:2